

Date: Monday, 6/12/2006 3:49:22 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE EXTRUSION
 Job Number : 27538
 Estimate Number : 10050
 P.O. Number : NIA Part Number : D6207
 This Issue : 6/12/2006 S.O. No. : NIA Drawing Number : D6207 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : MACHINED PARTS Drawing Revision : A
 Previous Run : NIA Material : NIA
 Written By : SPAA COMMENT BELOW Due Date : 6/19/2006 Qty: 20 Um: Each
 Checked & Approved By : QA 06.06.13
 Comment : Est. A: 02.03.15 New Issue NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 149206/15/06(20)

a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125"

b) Material: 6061-T6/T6511 (QQ-A-200/8)

c) Minimum ultimate tensile strenght = 38 ksi

d) Minimum yield tensile strenght = 35 ksi

2.0 D6207P Angle Extrusion 1x1x.125



Comment: Qty.: 1.0000 f(s)/Unit Total: 12.0000 f(s)

Angle Extrusion 1x1x.125

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

06/06/06(25)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6207

Check hardness with Webster tester

J.G06/06/20

5.0 PACKAGING 1 PACKAGING RESOURCE #1




Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: J.GJ.G06/08/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/08/17

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE EXTRUSION

Job Number: 27538

Part Number: D6207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/17

Job Completion



u 06-08-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

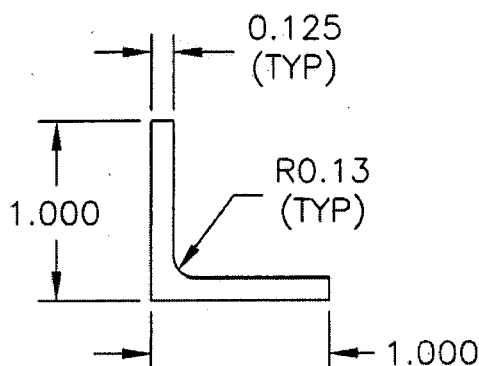
QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING



D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27538

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Aluminium Mill Certificate

Cert. No.: KAP604321

Customer: INTEGRIS METALS, LTD

Contract No.: CA-SM41597

Alloy Temper: 6061-T6511

Container No: OOLU 7271790/40'

Standards: ASTM-B221

Shipment Date: Jul 23 2004

PO No: 363153

Invoice No: M43537

			6061 Chemical Composition (%)												Tensile Strength		Yield Strength		Elongation	
Product Code	Die No	Specification	Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Pb	Bi	Zr	Al	N/mm ²	ksi	N/mm ²	ksi	%
				0.40-0.80	0.80-1.20	0.70 max.	0.15-0.40	0.15 max.	0.20 max.	0.04-0.35	0.15 max.	--	--	--	Rem.	265	38	245	36	8
5308-1025	6079	ANGLE 3/4X3/4X1/8RF	4D093	0.656	1.029	0.129	0.228	0.010	0.009	0.145	0.008				Rem.	302	44.0	269	39.0	13.5
5308-1075	6009-318	ANGLE 1X1X1/8RF	4D093	0.656	1.029	0.129	0.228	0.010	0.009	0.145	0.008				Rem.	327	47.0	275	40.0	12.1

Kam Kiu Aluminium Group hereby certifies that metal shipped under the above mentioned PO No, Contract No, and Container No has been inspected and tested, and found in conformance with the applicable specifications forming a part of the description set forth in Kam Kiu's Sales Contract.

Prepared By:

Checked By:

